

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009554**Date Inspected:** 12-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, OR**CWI Name:** Mike Gregson, Jose Salazar**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge K Pipe Beams**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Oregon Iron Works, Inc (OIW) in Clackamas, OR, to randomly observe the in process welding of the Hinge K Pipe Beam assemblies. The QA Inspector arrived on site to randomly observe the OIW Quality Control (QC) Inspectors in process and completed visual and nondestructive testing. Upon the arrival of the QA Inspector the following observations were made:

**OIW Fabrication Shop-Bay 3****Hinge-K Pipe Beam Assembly 102A-1: 10/12/09****a111-1 Forging to a110-1 Base Plate**

QA Inspector noticed that OIW had previously placed this forging assembly 102A-1 in position and was in-process of machining the completed stiffeners, utilizing a mechanical machining bit. QA Inspector had previously measured the stiffener heights to be approximately 662mm and noted that approximately 12mm of material (485W) was in process of being removed, to achieve a desired result of 650mm (+3mm/-10mm), which is in accordance to contract requirements. QA Inspector had previously spoken with OIW machinist and OIW explained that the mechanical machining bit was set to remove approximately 1/32" (.8mm) of material (485W), per each cutting pass. QA Inspector noted that once the machining process is complete, OIW will perform dimensional measurements utilizing a laser tracker, prior to fitting the a109 (Post Tension Cap) plates.

**Hinge-K Pipe Beam Fuse Assembly 120A-3: 10/12/09****a124-12 Half Fuse to a124-10 Half Fuse**

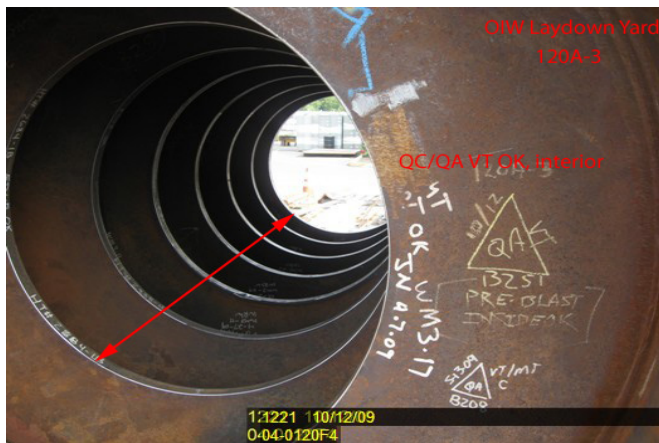
QA Inspector spoke with QC Inspector Jose Salazar and Mr. Salazar explained that welder #F17, Mr. Igor Frolov, was currently in-process, of performing the weld clean-up and grinding, on the previously marked interior of fuse

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QA Inspector noted that this fuse assembly 120A-3, would be transferred to OIW Vancouver, WA. painting facility and the interior blasted at a later date and an OIW QC Inspector and QA Inspector will then perform an after blast visual inspection, per AWS D1.5 and contract requirements, prior to OIW applying inorganic zinc primer coat. See attached picture below.

## Material, Equipment, and Labor Tracking

QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project. The QA Inspector observed at Oregon Iron Works: 5 OIW production personnel and 2 QC Inspectors.



### Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

**Inspected By:** Vance,Sean

## Quality Assurance Inspector

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## WELDING INSPECTION REPORT

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**Reviewed By:** Adame,Joe

QA Reviewer